

Work Order ID 52167

Thursday, September 17, 2009 10:32:34 AM



Page 1

Item ID: D3570-2

Accept



Setup Start



Revision ID: E

Stop



Item Name: Bracket

Start Date: 9/17/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 9/25/2009 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

DF mt

Date:

09-9-17

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3570 | Rev E | | | | | | | | |

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3570 ☐ Dwg Rev: E ☐ Prog Rev: E ☐ 2-
Deburr if necessary

Deburr m-l 09/10/14

IB 9-10-13

32X

32

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

IB 9-10-13

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

27 8/21/14

counted
32

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Page 2

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Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

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|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Form as per Dwg D3570 Using DT8945 □ 2-Cut excess materials as per Dwg D3570. □ 3-Drill as per Dwg D3570 Using Dt8946

= 7m-h 09/11/04

(32x)

140

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

= 2 09/11/05

center
(32)

150

0.00



HandFinish

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

Hand Finishing

= 11 09/11/05

(x32)

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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|----------------------|----------------|-----------------|--------------|---------------|---------------|------------------|----------------|
| 160 Powdercoat Powder Coating | Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo START TIME: <u>7:00AM</u> OVEN TEMPERATURE: <u>7:20AM</u> FINISH TIME: <u>3:20PM</u> | 0.00 0.00 | <u>714</u> | <u>09/11/06</u> | <u>XB2</u> | <u>Ø</u> | | | |
| 170 QC Quality Control | QC3- Inspect Part Finish Memo | 0.00 0.00 | <u>MD</u> | <u>09/11/06</u> | <u>X32</u> | | | | |
| 180 Packaging Packaging | Identify as per dwg & Stock Location <u>245A</u> Memo | 0.00 0.00 | | | | <u>9/11/9</u> | <u>(320)</u> | <u>SP</u> | |

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Page 4

Item ID: D3570-2

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Item Name: Bracket

Start Date: 9/17/2009 Start Qty: 20.00

Required Date: 9/25/2009 Req'd Qty: 20.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| 190 | QC21 - Final Inspection - Work Order Release | 0.00 | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

09/11/09
MF
09-11-09

Picklist Print

Page 1

Thursday, September 17, 2009 10:32:33 AM

Work Order ID: 52167



Parent Item: D3570-2RevE



Parent Item Name: Bracket


Start Date: 9/17/2009

Required Date: 9/25/2009

Comments:

Start Qty: 20.00

Required Qty: 20.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| M6061T6S.125 | | Purchased | No | | | | sf | 130.4306 | 1.4007 | 2.2411 | | |
|  | | | | | | | | | | | | |
| 6061-T6 .125 Sheet | | | | | | | | | | | | |

B 9-10-13

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u> | | |
| Main Warehouse | | |
| MAT | 130.4306 | |
| 110062 | 1.85 | |
| 111642 | 32.5806 | |
| 112476 | 32 | |
| 112567 | 64 | |

112567

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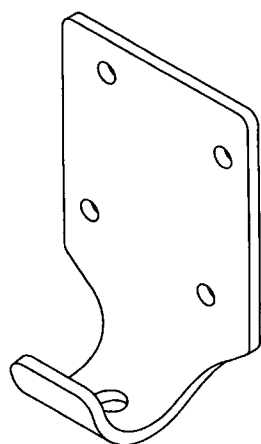
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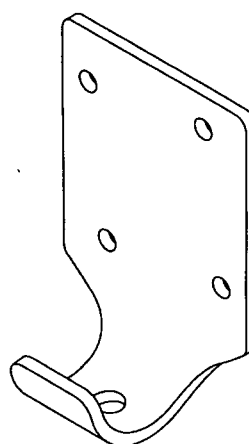
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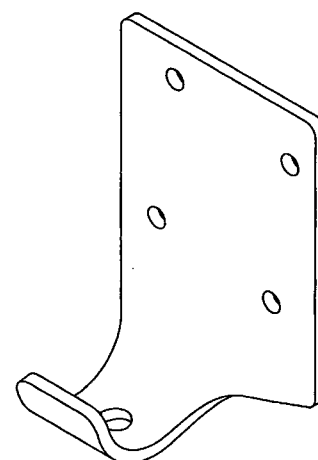
NO. 52167



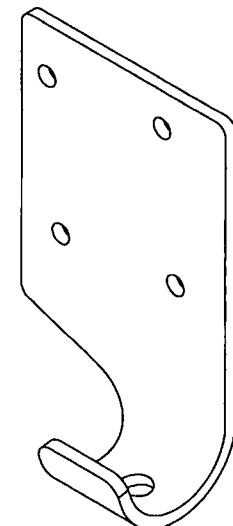
D3570-1 BRACKET



D3570-2 BRACKET



D3570-3 BRACKET



D3570-4 BRACKET

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09/04/22

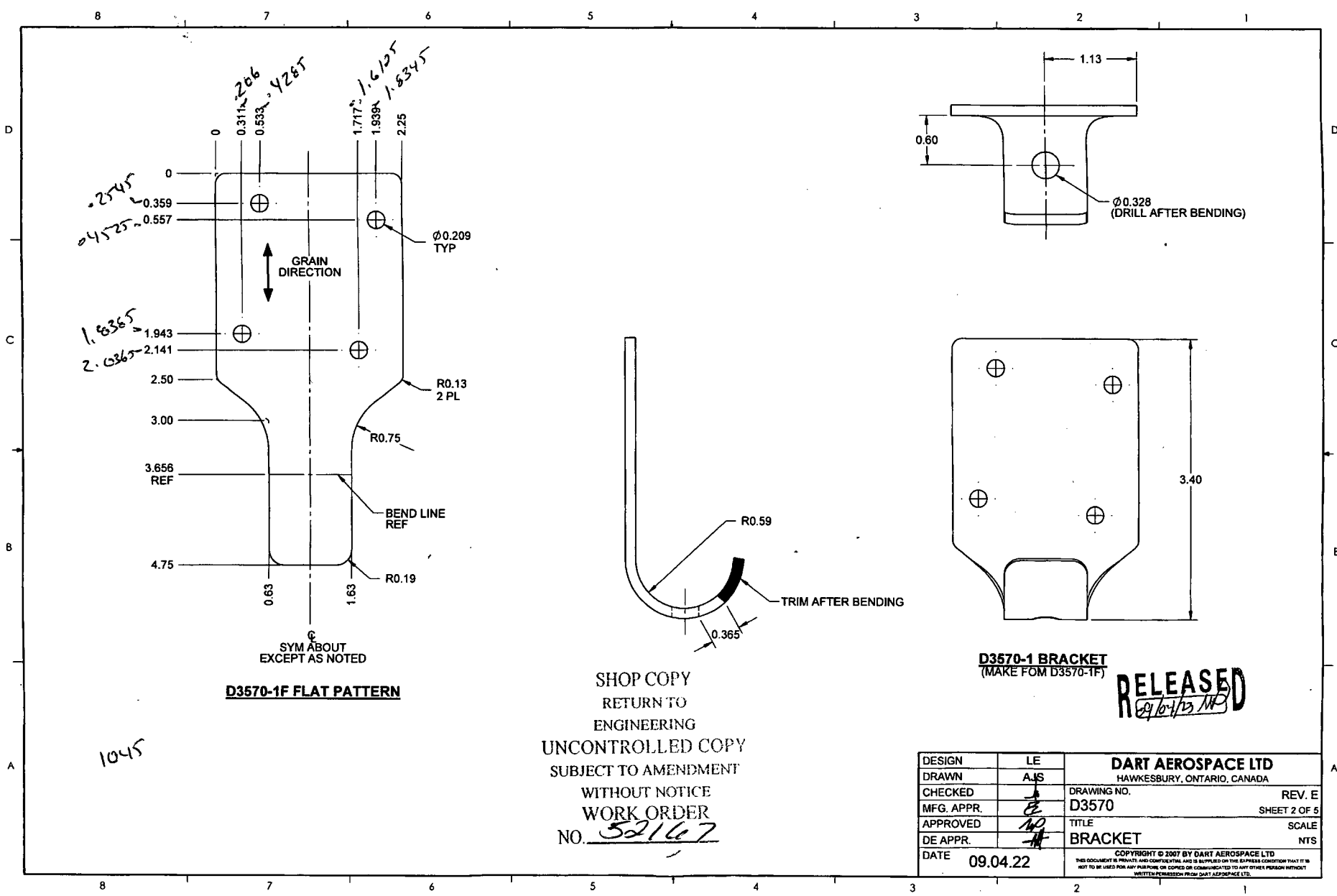
NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM 0.125 THICK PER AMS-QQ-A-250/11 OR AMS 4025/4027
REF DART SPEC M8061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3570-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.10 lbs EACH

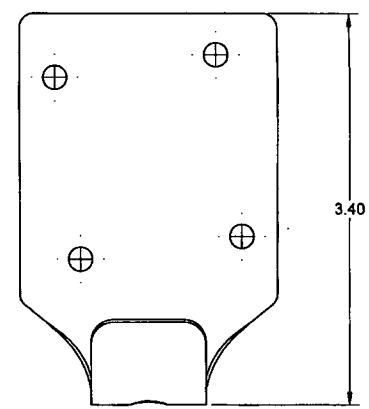
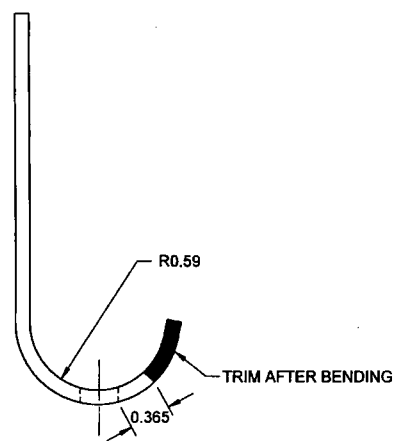
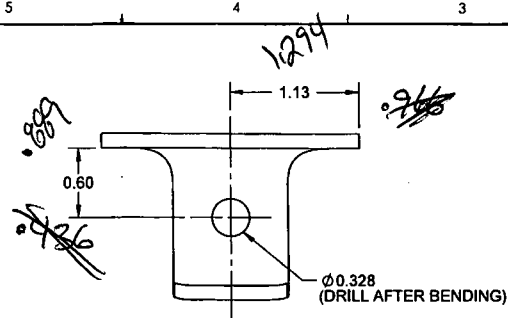
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WORK ORDER
NO. 52167

| E | SHEET 3 UPDATED D3570-3F FLAT PATTERN. SEE REV D FOR DETAILS. SEE PAR 09-014. | AJS | 09.04.22 |
|------------|---|--|--------------|
| D | ADDED -3 & -4 FOR USE ON 214B/B1. SEE PAR 09-014. | AJS | 09.04.01 |
| C | UPDATE DIMS FOR CLARITY | LE | 07.06.01 |
| B | CHANGE BEND RAD TO 0.60 FROM 0.50 | LE | 07.04.16 |
| A | NEW ISSUE | LE | 07.02.07 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | LE | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | AJS | | |
| CHECKED | J | DRAWING NO. | REV. E |
| MFG. APPR. | B | D3570 | SHEET 1 OF 5 |
| APPROVED | AP | TITLE | SCALE |
| DE APPR. | AP | BRACKET | NTS |
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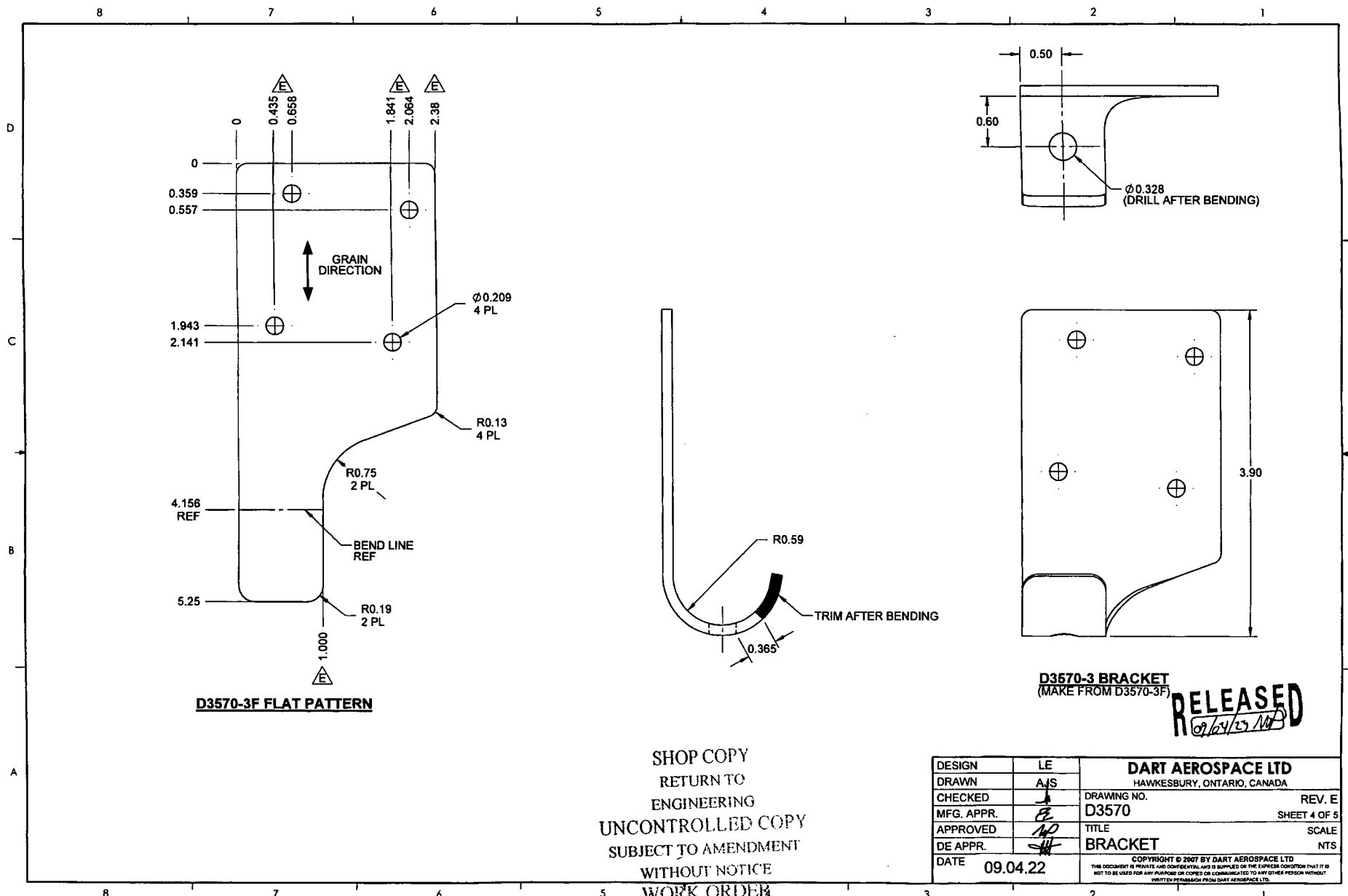
D3570-2 BRACKET
(MAKE FROM D3570-1F)

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09/04/22

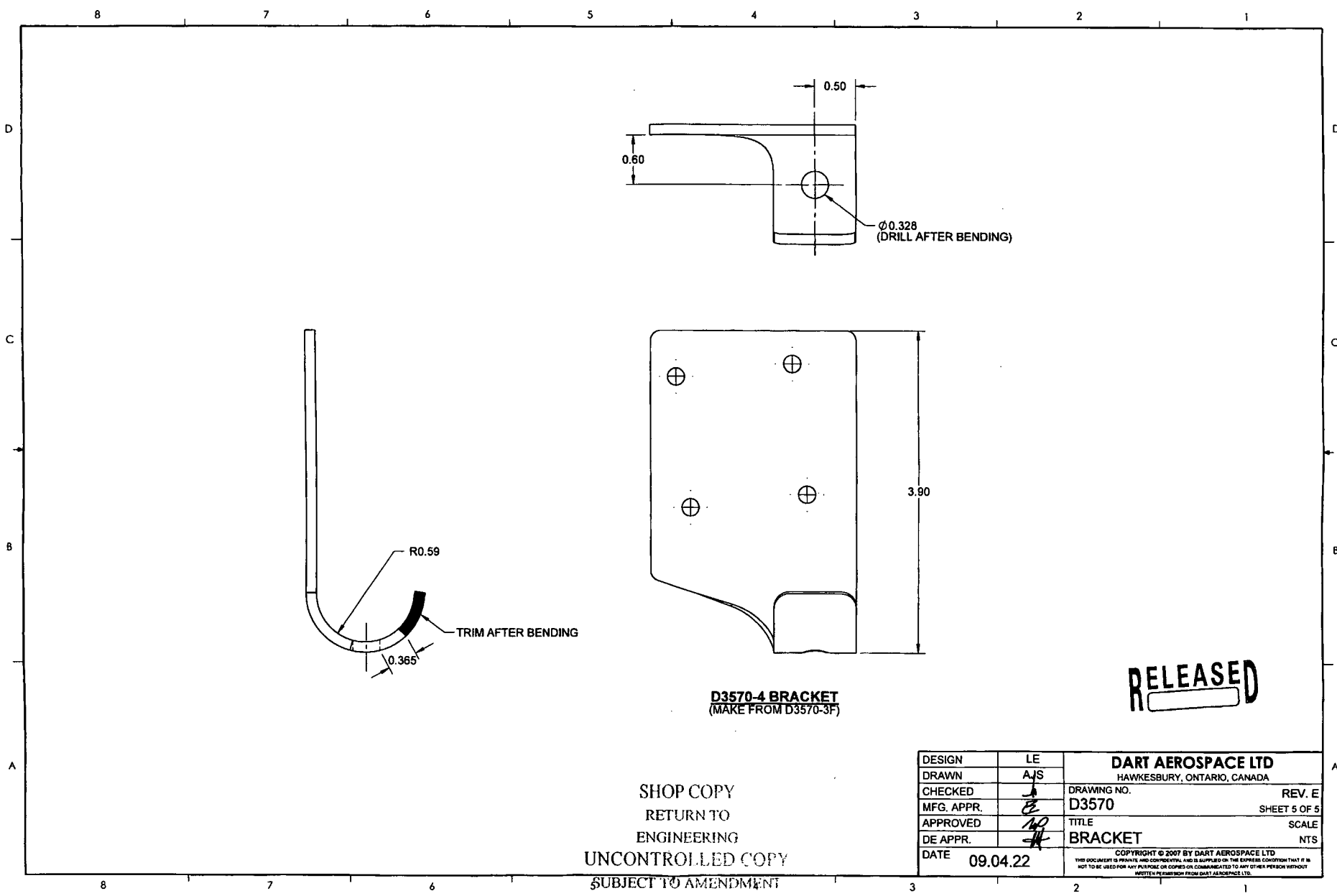
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| DRAWN | AJS | | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. E |
| MFG. APPR. | <i>[Signature]</i> | D3570 | SHEET 3 OF 5 |
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09/24/23 MB

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D3570-4 BRACKET
(MAKE FROM D3570-3F)

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| DRAWN | AJS | | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. D3570 | REV. E |
| MFG. APPR. | <i>[Signature]</i> | SHEET 5 OF 5 | |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
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